



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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SWA3-100

Job Sheet 203125



Part No: SWA3-100

Job Qty: 10 pcs

Part Name: Upper End - Swa3 Swivel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 12/13/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG SWA3-100 Rev 15 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Bandsaw - 1	10 pcs	12/13/19	12/13/19	0.00	1.00	Bandsaw - 1	
110	NLX 2500SY - B4B	10 pcs	12/13/19	12/13/19	1.00	10.00	NLX 2500SY - 1 - B4B	
120	QC 2	10 pcs	12/13/19	12/13/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



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Container No: S235426



Part: SWA3-100

Job No: 203125

Serial No/Batch: S235426

Revision: 15

Inspector:

Exp Date:

Instructions:

Date: 11/27/19

Plex 11/11/19 9:59 AM Dart.Renwick.Jennife

130 QC 8	10 pcs	12/13/19	0.00	0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	SL H-12-16
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140 Packaging 3-1 - Stock - B4B	10 pcs	12/13/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	

					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	DEC 17 2019
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	10 pcs	12/13/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	DEC 17 2019

Part Op 100 - (Bandsaw) Cut Blanks to 6.250"
Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG. FC330 FOLIO REV: KA DWG REV: 15
2-Deburr ***Machine engrave S/N number and machine engrave UP arrow***
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____)
150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.000	17-4 SS Round Bar 2.000"	5.2000 ft (.52 ea)	100-Bandsaw - 1	S196 721 S196 721

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R2.000	5	14	0

Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order:	203 125
Description: upper end SWA3 swivel		Part Number:	SWA3-100
Inspection Dwg: SWA3-100	Rev: 15	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.33	$\pm .01$	1.33			vernier	
$\phi 1.325$	$\pm .005 / - .000$	1.328			vernier	
$\phi 1.570$	$\pm .003 / - .000$	1.5715			112-177 & Mic Lp2	
R.187	$\pm .005$	.187			Rad-gauge	
$\phi .015 \times 45^\circ$	$\pm .005 \times .5^\circ$	$\phi .015 \times 45^\circ$			vernier	
.27	$\pm .01$	.271			H-gauge	
$\phi 1.70$	$\pm .01$	1.700				
$\phi 1.50$	$\pm .01$	1.500				
$\phi .75$	$\pm .01$	.750				
45°	$\pm .5^\circ$	45°				
6.15	$\pm .01$	6.155				
2.70	$\pm .01$	2.705				
1.31	$\pm .01$	1.315				
R.25	$\pm .01$	.250			Rad gauge	
R.03	$\pm .01$	.032			↓	
$\phi .640$	$\pm .01 / - .000$	.643			gauge pin	
.81	$\pm .01$	.810			H-gauge	
1.985	$\pm .005$	1.994				
1.28	$\pm .01 / - .00$	1.284				
$\phi .98$	$\pm .01$	.980				
2.46	$\pm .01$	2.470				
3.90	$\pm .01$	3.900				
$\phi 2.00$	$\pm .01$	1.996				
$\phi 1.50$	$\pm .01$	1.500				
.75	$\pm .00 / - .02$	.740				
1.75	$\pm .01$	1.750			H-gauge	
4.01	$\pm .01$	4.015				
3.68	$\pm .01$	3.6825				
.285	$\pm .000 / .001$	.285				

Measured by: <i>[Signature]</i>	Checked by:	QC Inspector:
Date: 14-11-30	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

